

**Work Order ID 59355**

Wednesday, June 02, 2010 11:32:50 AM

Page 1

Item ID: D350-591-214

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli-Access-Step, Short RH

Start Date: 6/2/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 6/9/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan: MF

Date: 10-6-3 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3078

A

DSI 9472

A

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and type labels as per PPP D350-591-214 CHG003

10/06/10

HJ for BG 10/06/10 Pto -&gt;

110

0.00



Large Fab

Large Fab

Large Fab

Memo

0.00

1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078  
2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets.  
3-Deburr

10.06.09

4

W/O: 59355

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/6/15	100	Per. Jimmy Fix Routing numbers n by OPPS. 10/06/15					10/06/15

Part No: D350-591-214 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item ID: D350-591-214

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Cust Item ID:

Required Date: 6/9/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00				(X4)			
Quality Control									
130	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8681, weld Fwd End Plate as per QSI 004 & Dwg D3078 A/RAluminum Rod <u>M112860</u> 3-Grind End Plate flush <u>M114242</u>								
140	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00				(4)			
Quality Control									

S10/06/07

10.06.09 4 P

(4) 10.06.09

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Item ID: D350-591-214

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Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Short RH

Start Date: 6/2/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 6/9/2010 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00		8 10/06/09					
160  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00		10-06-09		4			
170  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00		SAD 10-06-09					

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Cust Item ID:

Required Date: 6/9/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

200

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- Rivet Leg Assembly as per Dwg D3078.

2-Bevel Aft end for welding

3-Inspect for foreign object as per QSI 024

4-Weld Aft End Plate as per QSI 004 & Dwg D3078  
A/R Aluminum Rod *1112860*

5-Grind End Plate flush

*10.06.11**4**φ*

210

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

*④ 10.06.14*

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Required Date: 6/9/2010 Req'd Qty: 4.00

Customer:

Reference:

Run Start

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

220

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 10/06/14

44  
RH

230

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

4 RH 10-8-14

240

White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 12:00 PM  
OVEN TEMPERATURE: 320°F  
FINISH TIME: 12:30 PM

=> 4/10/06/14 4 RH



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Required Date: 6/9/2010 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

250

Wing Walk as per dwg QSI005 4.4 Batch \_\_\_\_\_ 0.00

0.00



HandFinish

Memo

0.00

Hand Finishing

M114432

H BR 10-6-15

260

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

M 10 06 15 (4)

270

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10-6-17 SL (4)



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Start Date: 6/2/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 6/9/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

280

QC4- 100% Inspect kits for completeness

0.00

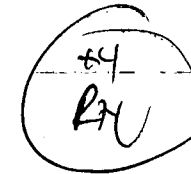


QC

Memo

0.00

5/10/06/17



Quality Control

290

Packaging

0.00



Packaging

Memo

0.00

Identify and pack for shipping as per PPP D350-591-214

Location:

PPP Rev: R

10/06/17

300

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

10/06/17  
mf  
10-6-17

Quality Control

# Picklist Print

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Page 1

Work Order ID: 59355

Parent Item: D350-591-214

Parent Item Name: Heli-Access-Step, Short RH

Comments: IPP Rev:B 05.10.14 Modified step 10 KJ/EC  
IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM  
IPP Rev:C 06-06-27 Revised as per DSI9340 JLM

Start Date: 6/2/2010

Required Date: 6/9/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per-Kit	Total	Qty	Date	Status
AN3-35A		Purchased	No			<del>270</del> 260	Each	65.0000	2	8			

Bolt

Location Loc Qty Loc Code

ST353 65  
114382 35  
114784 30

AN4-11A

Purchased

No

~~270~~  
260 Each

349.0000

6 24

Bolt

Location Loc Qty Loc Code

ST357 349  
110382 349

AN4-13A

Purchased

No

~~270~~  
260 Each

283.0000

4 16

Bolt

Location Loc Qty Loc Code

ST351 -8  
114523 -8  
ST357 291  
114752 291

AN4-16A

Purchased

No

~~270~~  
260 Each

145.0000

4 16

Bolt

Location Loc Qty Loc Code

ST358 145  
114330 45  
114523 100

16

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Page 2

Work Order ID: 59355

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IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM  
IPP Rev:C 06-06-27 Revised as per DSI9340 JLM

Start Date: 6/2/2010

Required Date: 6/9/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per-Kit	Total	Qty	Date	Status
AN960JD10	NAS1149D0363J	Purchased	No			270 260	Each	0.0000	4	16			
Washer													
AN960JD416	NAS1149D0463J	Purchased	No			270 260	Each	0.0000	12	48			
Washer													
D2230-1		Manufactured	No			270 260	Each	85.0000	2	8			
Lug													

Location	Loc Qty	Loc Code
ST476	85	
51566	4	
54755	5	
57828	76	

D2230-3		Manufactured	No			270 260	Each	29.0000	2	8			
Lug													

Location	Loc Qty	Loc Code
ST476	29	
57827	29	

D2622-120C		Manufactured	No			110	Each	30.0000	0.5	2			
Step Extrusion													

Location	Loc Qty	Loc Code
WA	30	
55214	30	

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Start Date: 6/2/2010

Required Date: 6/9/2010

Comments: IPP Rev: B 05.10.14 Modified step 10 KJ/EC  
IPP Rev: C 06-06-19 Added D2732-030 AS PER DSI9294 JLM  
IPP Rev: C 06-06-27 Revised as per DSI9340 JLM

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
D2732		Manufactured	No			270	f	428.8000	1	4			
Rubber Extrusion													

Sy  
measured 8 to 10 lb

Location	Loc Qty	Loc Code
ST412	428.8	
56516	428.8	

10.6.17 S

Cut 3.00" long, qty 4

D2856-400

Manufactured No

270

f

252.9088

0.6

2.4



Abraison Strip

Location	Loc Qty	Loc Code
ST403	252.9088	
50593	45.8568	
56626	207.052	

10.6.17 SP

Sy  
measured 8 to 10 lb

cut 7.20" long, qty 1

D3063-1

Manufactured No

130

Each

12.0000

1

4



Support

Location	Loc Qty	Loc Code
WA	12	
51237	12	
	Each	
	44.0000	

10.06.09

D3065-041

Manufactured No

Each

44.0000

1

4



Step Leg Assembly Hi

Location	Loc Qty	Loc Code
WA	44	
58160	4	
58536	40	

10.06.10

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Parent Item Name: Heli-Access-Step, Short RH





Comments: IPP Rev:B 05.10.14 Modified step 10 KJ/EC  
IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM  
IPP Rev:C 06-06-27 Revised as per DSI9340 JLM

Start Date: 6/2/2010

Required Date: 6/9/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
D3066-1		Manufactured	No				Each	137.0000	2	8			
<div>  </div>													
Spacer													
<div> <div> <div>Location</div> <div>WA</div> <div>57920</div> <div>58540</div> </div> <div> <div>Loc Qty</div> <div>137</div> <div>37</div> <div>100</div> </div> <div> <div>Loc Code</div> </div> </div>													
D3067-1		Manufactured	No			130	Each	63.0000	1	4			
<div>  </div>													
End Plate													
<div> <div> <div>Location</div> <div>WA</div> <div>57926</div> </div> <div> <div>Loc Qty</div> <div>63</div> <div>63</div> </div> <div> <div>Loc Code</div> </div> </div>													
D3067-1		Manufactured	No			200	Each	63.0000	1	4			
<div>  </div>													
End Plate													
<div> <div> <div>Location</div> <div>WA</div> <div>57926</div> </div> <div> <div>Loc Qty</div> <div>63</div> <div>63</div> </div> <div> <div>Loc Code</div> </div> </div>													
MS20600-AD4W4		Purchased	No				Each	439.0000	16	64			
<div>  </div>													
Rivets													
<div> <div> <div>Location</div> <div>ST309</div> <div>114761</div> <div>ST321</div> <div>113368</div> <div>114181</div> <div>114718</div> </div> <div> <div>Loc Qty</div> <div>66</div> <div>66</div> <div>373</div> <div>62</div> <div>11</div> <div>300</div> </div> <div> <div>Loc Code</div> </div> </div>													

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# Picklist Print

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Page 5

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Start Date: 6/2/2010

Required Date: 6/9/2010

Comments: IPP Rev:B 05.10.14 Modified step 10 KJ/EC  
IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM  
IPP Rev:C 06-06-27 Revised as per DSI9340 JLM

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
MS21042L3		Purchased	No			270	Each	3,576.000	2	18			
<i>S</i> <i>4</i> Nut													

Location	Loc Qty	Loc Code
ST300	3576	
113537	20	
113644	56	
<u>114523</u>	1000	
114718	500	
114784	2000	

MS21042L4	Purchased	No				270	Each	4,135.000	6	24			
<i>S</i> <i>4</i> Nut													

Location	Loc Qty	Loc Code
ST139	2	
111827	2	
ST300	4133	
113422	76	
<u>114523</u>	1049	
114718	1000	
114784	2000	
9063	8	

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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. <b>D3078</b>	REV. A SHEET 1 OF 2
DATE <b>02.09.11</b>		TITLE <b>STEP ASSEMBLY, HI SHORT</b> SCALE NTS	
A	02.09.11	NEW ISSUE	

RELEASED  
02.09.20 *#*

#59355

Part No.	Description	QTY -041	QTY -042
D3078-041	Step Assembly, High Short (LH)	X	
D3078-042	Step Assembly, High Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3063-1	SUPPORT	1	1
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

**GENERAL NOTES:**

- 1) -041 SHOWN, FOR -042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

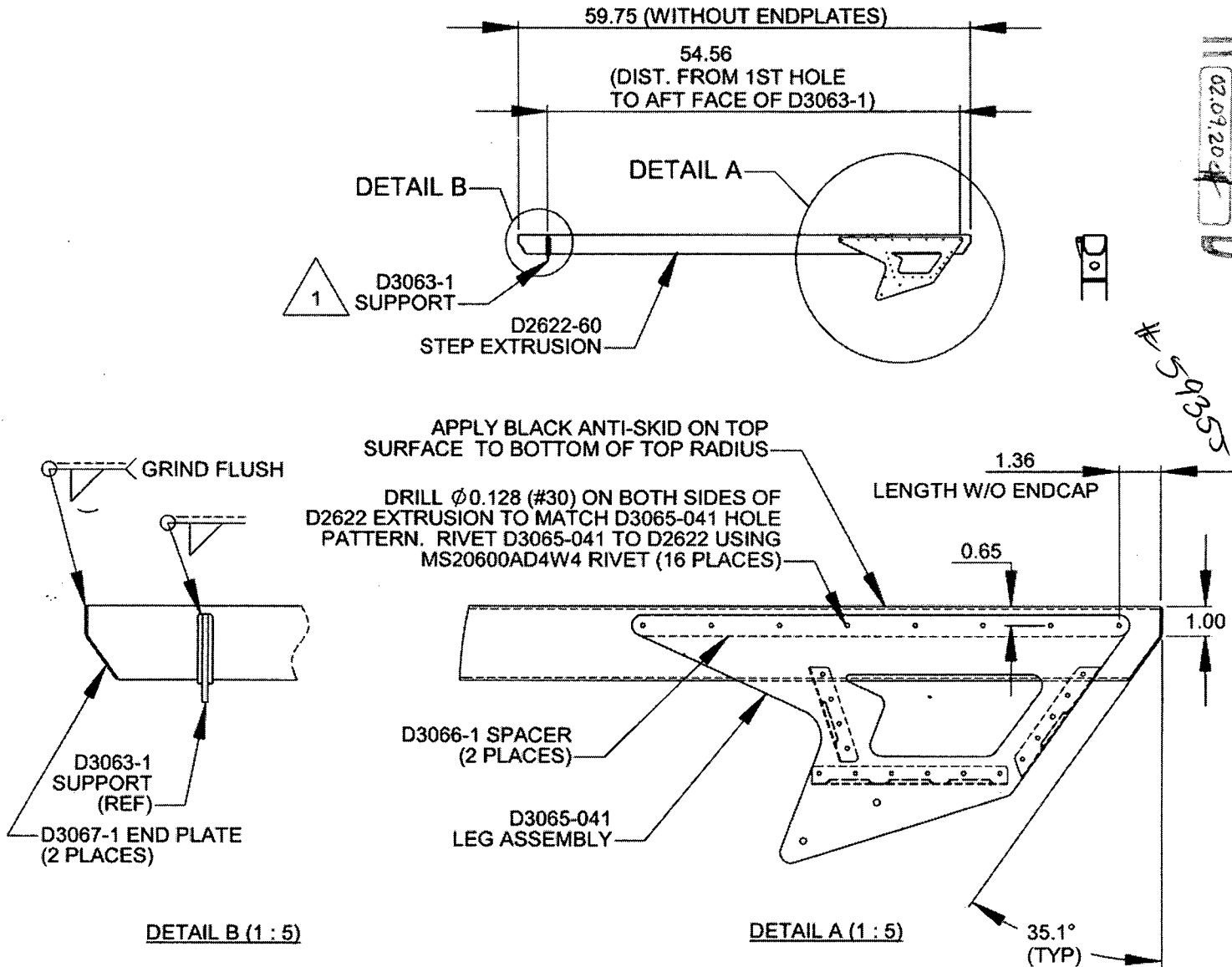


**DART**



DESIGN	D	DRAWN BY	D	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED	A	APPROVED	A	DRAWING NO. <b>D3078</b>
DATE	02.09.11	TITLE	STEP ASSEMBLY, HI SHORT	REV. A SHEET 2 OF 2
		SCALE	1:20	

RELEASED  
02.09.2014



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

\*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER  
AND  
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER  
REF CANADIAN STC: SH92-6  
REF FAA STC: SH967NE



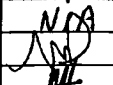

For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying crosstube diameters and to improve fit, as indicted in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.

For D350-591-213/-214/-215/-216 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:

Qty -213-	Qty -214	Qty -215	Qty -216	Part Number	Description
X				D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
4	4	4	4	AN4-16A	BOLT

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED  BY: D. SHEPHERD (DE # 02)	
DATE:	09.08.05
CERT. NO.:	SH92-6
ISSUE NO.:	11

A	NEW ISSUE		RF	09.08.05
REV.	DESCRIPTION		BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.	N/A	DSI 9472	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.		BOLT ADDITION	NTS	
DATE	09.08.05		COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries